

Work Order ID 133634

133634

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June-30-15 3:09:06 PM

Item ID: MISC - Testing Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Eng Testing
 Start Date: 6/12/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/12/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
100		0.00							
100		0.00							
Crosstubes									
Crosstubes									

Memo

- Pick D6021 **M177271**
- Machine to 2.3" OD x 6" Long
- Grind surface smooth using GR80 drum belt and finish with a coarse Blendex™ drum (Walter Surface Technologies). Circumferential grind marks are unacceptable.
- Degrease using 4105S Wash 'n Wipe. Use clean lint free cloth. Rinse any residue thoroughly, Wipe/dry with clean dry cloth to ensure surface contaminants removed.
- Keep all surfaces clean until primed. Use clean gloves to handle. Surfaces shall be kept free from dirt, dust, finger marks, and other contaminants.

DAS 12 9-89 15/5/20

110		0.00							
110		0.00							
Eng									
Engineering									

Memo

Engineering Approval

DAS 12 9-89 15/5/20

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
120									
SprayPaint	Memo	0.00							
Spray Painting	6. Apply Sherwin Williams DOD-P-15328D per manufacturer's instructions. • M132240 7. Prime and paint outside of tube per Dart QSI 005 4.2 130992 132422								
130		0.00							
130									
Eng	Memo	0.00							
Engineering	Eng Approval								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

FOR TESTING
ONLY U 15/6/30

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